

Date: Monday, 25/05/2009 3:29:14 PM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350/212/130 BASKET LID
 Job Number : 48202A
 Estimate Number : 10193
 P.O. Number :
 This Issue : 25/05/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run : 48096B
 Part Number : D2512
 Drawing Number : D2512 REVE
 Project Number :
 Drawing Revision : E
 Material :
 Due Date : 01/06/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : MF 09-05-26
 Comment : Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/
 RF
 Est Rev:N 06.04.05 Added level21 EC
 Est Rev:O 08-08-29 revE as per dwg DD verified by:EC
 Est Rev:P 08-09-24 plug holes prior to powder coating DD
 verified by:EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
✓ 1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
	Comment: Qty.: 45.7594 f(s)/Unit Total: 45.7594 f(s) EVID OF BAR SCRAP 20" <u>111432</u> Pick: =1.66 f(s) 3/4"x3/4" 304/316 SS tube .065" wall Batch: <u>111432</u> <u>SM 09/05/26</u>	
✓ 2.0	D31663	Basket Hoop
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3166-3 Basket Hoop <u>B47073</u> <u>SM 09/05/26</u>	
✓ 3.0	D2506	Label Plate
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2506 Label Plate <u>B44275</u> <u>SM 09/05/27</u>	

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 4.0

D23271

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-1

Bushing

B46325

SY 09/05/26

✓ 5.0

D22321

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

Hinge plate

B46709

SY 09/05/26

✓ 6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B46086

SY 09/05/26

✓ 7.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf

M304EX0.75-16F Expanded Metal

M111630(16)
M111444 (2)

4(34)
98%

SAD

09-05-26

6

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512 SY

2-Cut (4) D2236 From D3166-3 SY

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305 SY

5-Weld as per Dwg D2512 using Dt9436 SY

SY 09/05/27 (14)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Pl 09.05.27

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

8 02/5/28 (K)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M 111 472

- 1- Plug holes in D2581 and in D2327-1 bushing prior to powder coating
- 2- Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME: *10:50 AM*

OVEN TEMPERATURE: *400°F*

FINISH TIME: *11:20 AM*

2ND COAT:

START TIME: *11:30 AM*

OVEN TEMPERATURE: *400°F*

FINISH TIME: *12:00 PM*

Pl 09.05.28 (K)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 *new* Batch: *M 111 013*

Spray paint: M 111 301

Pl 09/05/28 (K)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pl 04-05-28 (K)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *DDP 48202*

9/5/29

(K)

SP

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Job Number: 48202A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/09 MF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-09

W/O:		WORK ORDER CHANGES					
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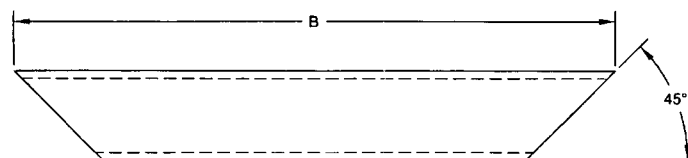
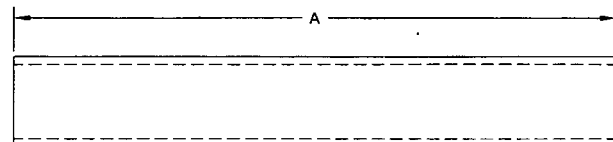
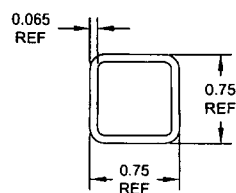
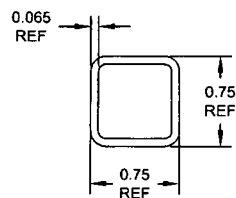
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PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



RELEASED
08-06-21-178

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO 'B' FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS. INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR DISSEMINATION TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD.</small>	

D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

* 48202A

W/O:		WORK ORDER CHANGES					
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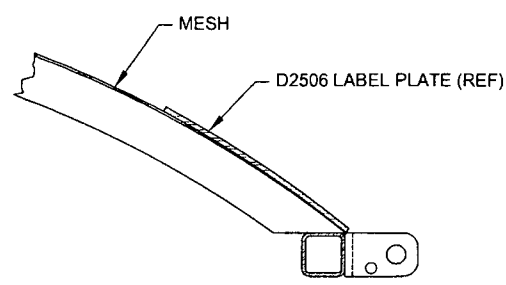
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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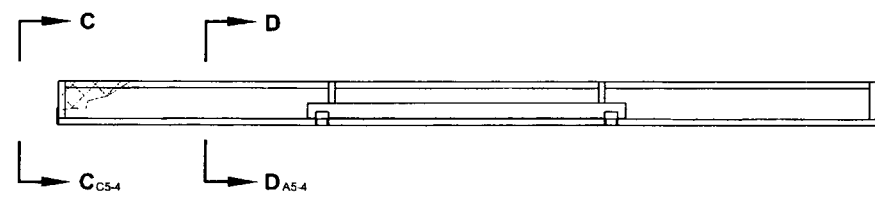
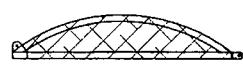
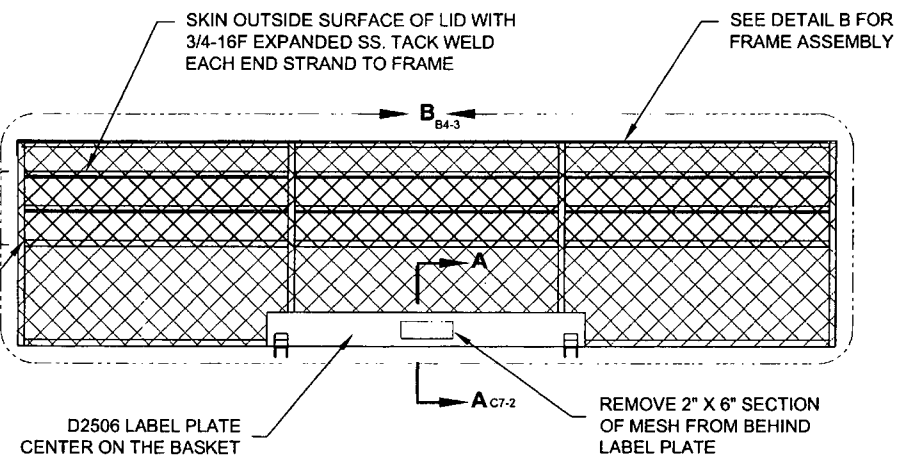
8 7 6 5 4 3 2 1



SECTION A-A^{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

#48202A

RELEASED
08-05-21/17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1

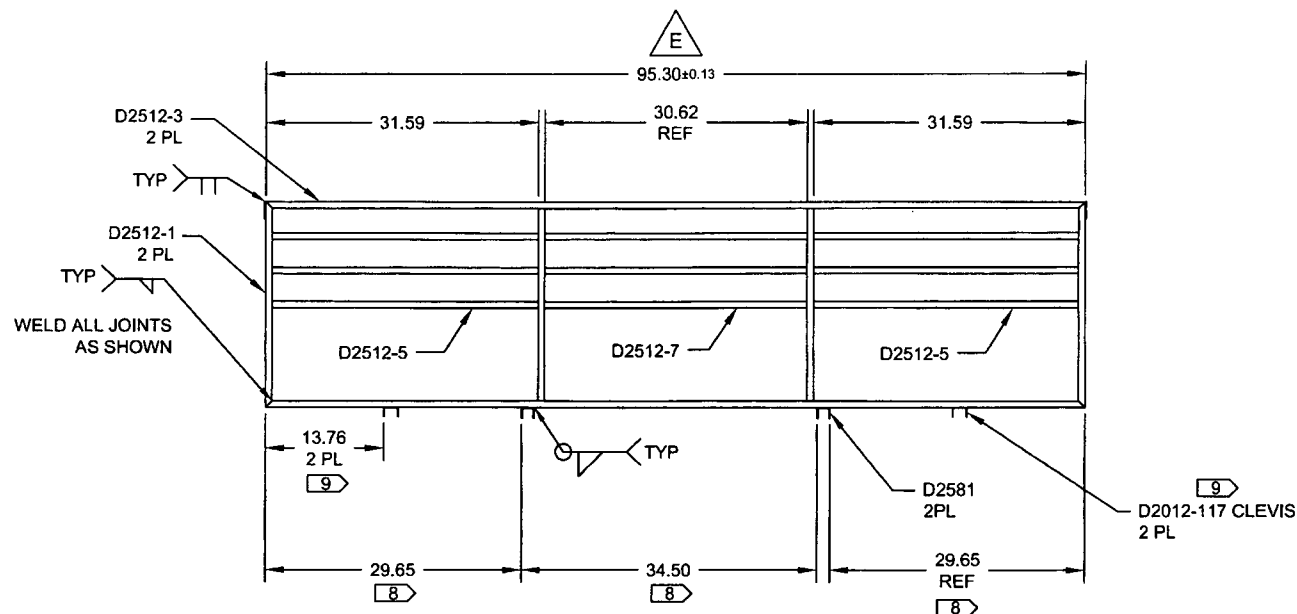
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

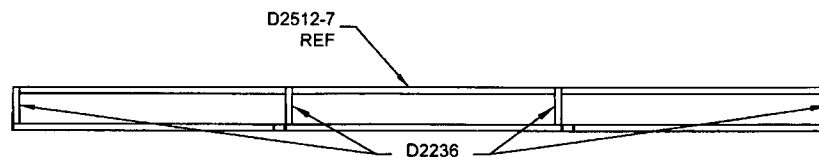
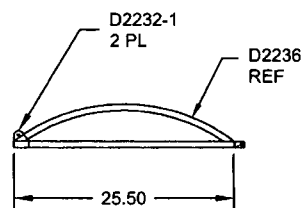
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DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR CLARITY



NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

#482020

RELEASED
08 06 21 1988

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 3 OF 4
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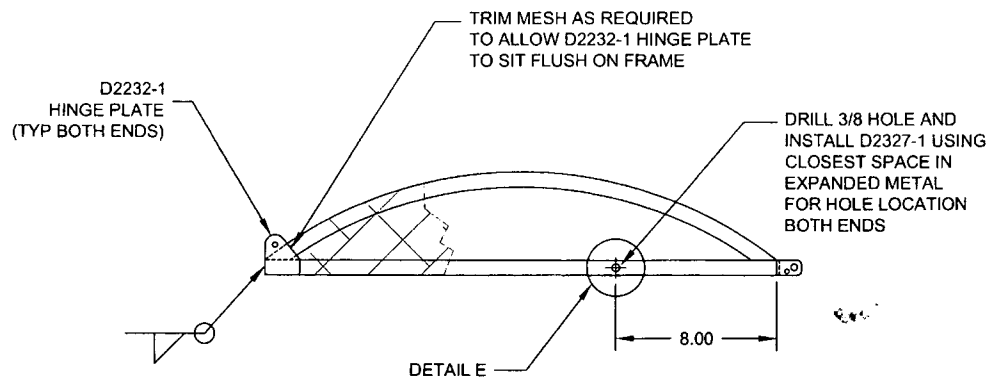
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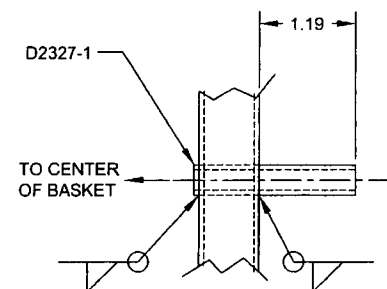
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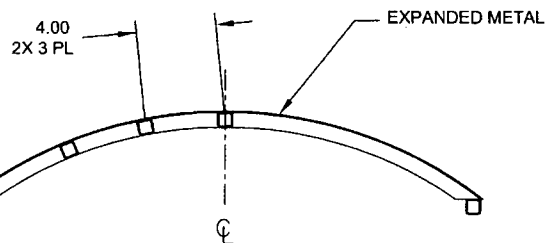
8 7 6 5 4 3 2 1



VIEW C-C SIMILAR BOTH END RIBS A5-2



DETAIL E C6-4



SECTION D-D SAME BOTH CENTER RIBS A4-2

#4820214

RELEASED
08-06-21/17

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DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
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8 7 6 5 4 3 2 1

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